

5/21

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23161
<b>Description:</b> Dual Disabling Kit (Medium Bell)		<b>Part Number:</b>	D412-738-011
B 05.05.10		<b>Keyed:</b>	<input checked="" type="checkbox"/> Alike <input type="checkbox"/> Unalike
<b>Dwg:</b> D3368 Rev. A; D3369 Rev. A1 page 4; D3371 Rev. A page 4; D3393 Rev. A page 1		<b>Qty:</b>	10
		Page 1 of 3	

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	AR	05/05/10	10																				
2	DC	Photocopy bluefile and create labels per PPP D412-738-011 <b>CHG001</b>	AR	05.05.26	10																				
3	GA	<b>Pick:</b> <table border="1"><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D2728-7</td><td>Decal</td><td></td></tr><tr><td>1</td><td>D3373-1</td><td>Cam Lock</td><td></td></tr><tr><td>1</td><td>D3393-1</td><td>Battery Lock Casing</td><td></td></tr><tr><td>1</td><td>D3393-3</td><td>Cam Lock Shaft</td><td></td></tr></tbody></table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal		1	D3373-1	Cam Lock		1	D3393-1	Battery Lock Casing		1	D3393-3	Cam Lock Shaft				
Qty	Part Number	Description	Batch																						
1	D2728-7	Decal																							
1	D3373-1	Cam Lock																							
1	D3393-1	Battery Lock Casing																							
1	D3393-3	Cam Lock Shaft																							
4	GA	Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.																							
5	GA	Using the flat cam, fabricate D3369-5 as per Dwg D3369 <b>Identify as D3369-5</b>																							
6	GA	Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten with lock body nut, apply locktite, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3393-3 shaft into lock, then install decal. <b>Pick:</b> <table border="1"><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3369-5</td><td>Washer</td><td></td></tr><tr><td>2</td><td>5/16WC</td><td>SS Flat Washer</td><td></td></tr><tr><td>A/R</td><td>N/A</td><td>262 Locktite</td><td></td></tr></tbody></table> <b>Identify as D3393-041 and attach keys. Ensure that assembly locks and unlocks smoothly.</b> <b>Record the Key Number on page 3</b>	Qty	Part Number	Description	Batch	1	D3369-5	Washer		2	5/16WC	SS Flat Washer		A/R	N/A	262 Locktite								
Qty	Part Number	Description	Batch																						
1	D3369-5	Washer																							
2	5/16WC	SS Flat Washer																							
A/R	N/A	262 Locktite																							
7	WS	Tack Weld lock shaft to flat cam <b>Pick:</b> <table border="1"><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>A/R</td><td>N/A</td><td>SS Rod</td><td></td></tr></tbody></table>	Qty	Part Number	Description	Batch	A/R	N/A	SS Rod																
Qty	Part Number	Description	Batch																						
A/R	N/A	SS Rod																							
8	GA	Apply crazy glue to caps then press caps into body. <b>Pick:</b> <table border="1"><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>2</td><td>9567K21</td><td>Polyethelene Cap</td><td></td></tr><tr><td>A/R</td><td>N/A</td><td>Krazy Glue</td><td></td></tr></tbody></table>	Qty	Part Number	Description	Batch	2	9567K21	Polyethelene Cap		A/R	N/A	Krazy Glue												
Qty	Part Number	Description	Batch																						
2	9567K21	Polyethelene Cap																							
A/R	N/A	Krazy Glue																							
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 <b>Mask Dowel Pins</b> <b>Pick:</b> <table border="1"><thead><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr></thead><tbody><tr><td>1</td><td>D3368-1</td><td>Pedal Lock Base</td><td>B22939</td></tr><tr><td>1</td><td>D3368-3</td><td>Pedal Lock Cover</td><td>B22940</td></tr><tr><td>1</td><td>D3385-1</td><td>Hinge</td><td>B22327</td></tr></tbody></table> <b>Identify as D3368-051</b>	Qty	Part Number	Description	Batch	1	D3368-1	Pedal Lock Base	B22939	1	D3368-3	Pedal Lock Cover	B22940	1	D3385-1	Hinge	B22327	W	05 05 12	10				
Qty	Part Number	Description	Batch																						
1	D3368-1	Pedal Lock Base	B22939																						
1	D3368-3	Pedal Lock Cover	B22940																						
1	D3385-1	Hinge	B22327																						
			SB	05/05/12	10																				
10	QC3	Inspect Powder Coat	SB	05/05/12	10																				

NIA  
2  
05-05-12

P10

RELEASED  
05-02-27

AR  
6/2/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05-05-12	9	Hinge is now A D3385-3 unpainted, instead of A -1  Permanent Change <i>[Signature]</i>	<i>[Signature]</i>	05-05-26	N/A	<i>[Signature]</i>	<i>[Signature]</i> 05-05-12

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

5/21

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23161
<b>Description:</b> Dual Disabling Kit (Medium Bell)		<b>Part Number:</b>	D412-738-011
<del>B F 05.05.10</del>		<b>Keyed:</b>	<input checked="" type="checkbox"/> Alike <input type="checkbox"/> Unalike
<b>Dwg:</b> D3368 Rev. A; D3369 Rev. A1 page 4; D3371 Rev. A page 4; D3393 Rev. A page 1		<b>Qty:</b>	10
		Page 2 of 3	

Step	Location	Procedure	By	Date	Qty																				
11	GA	Press dowel pins into D3368-3 pedal lock cover, then assemble hinge as per Dwg D3368 <b>Pick:</b> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2728-7</td> <td>Decal</td> <td>B22554</td> </tr> <tr> <td>1</td> <td>D3373-7</td> <td>Cam Lock</td> <td>B22944</td> </tr> <tr> <td>3</td> <td>238-028</td> <td>Ø3/16" Dowel Pin 1/2" long</td> <td>M16988</td> </tr> <tr> <td>4</td> <td>385-039</td> <td>Flat Head Screw</td> <td>M16699</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal	B22554	1	D3373-7	Cam Lock	B22944	3	238-028	Ø3/16" Dowel Pin 1/2" long	M16988	4	385-039	Flat Head Screw	M16699	SB	05/05/13	10
Qty	Part Number	Description	Batch																						
1	D2728-7	Decal	B22554																						
1	D3373-7	Cam Lock	B22944																						
3	238-028	Ø3/16" Dowel Pin 1/2" long	M16988																						
4	385-039	Flat Head Screw	M16699																						
12	GA	Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel. Discard the rest.	SB	05/05/13	10																				
13	GA	Fabricate D3371-5 Cam Lock as per Dwg D3371 <b>Identify as D3371-5</b>	SB	05/05/13	10																				
14	GA	Assemble lock mechanism and cam and install decal as per Dwg D3368. Apply 262 locktite to lock body nut. <b>Pick:</b> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>A/R</td> <td>N/A</td> <td>262 Locktite</td> <td>M16507</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	A/R	N/A	262 Locktite	M16507	SB	05/05/13	10												
Qty	Part Number	Description	Batch																						
A/R	N/A	262 Locktite	M16507																						
15	GA	Assemble lanyard to cyclic sock as per Dwg D3384 <b>Pick:</b> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3384-1</td> <td>Cyclic Sock</td> <td>B22340</td> </tr> <tr> <td>2</td> <td>CBL-460</td> <td>Loop Sleeve</td> <td>M16713</td> </tr> <tr> <td>28"</td> <td>CBL-1240</td> <td>Cable</td> <td>M16713</td> </tr> </tbody> </table> <b>Identify as D3384-047</b>	Qty	Part Number	Description	Batch	1	D3384-1	Cyclic Sock	B22340	2	CBL-460	Loop Sleeve	M16713	28"	CBL-1240	Cable	M16713	SB	05/05/13	10				
Qty	Part Number	Description	Batch																						
1	D3384-1	Cyclic Sock	B22340																						
2	CBL-460	Loop Sleeve	M16713																						
28"	CBL-1240	Cable	M16713																						
16	GA	Assemble D3384-047 to D3368-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3368. <b>Pick:</b> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>AN960-416</td> <td>Washer</td> <td>M5519</td> </tr> <tr> <td>1</td> <td>HX-81</td> <td>1/4"-20 SHCS 3/8" long</td> <td>M16971</td> </tr> </tbody> </table> <b>Identify as D3368-041 &amp; attach keys</b> <b>Record the Key Number on page 3</b>	Qty	Part Number	Description	Batch	2	AN960-416	Washer	M5519	1	HX-81	1/4"-20 SHCS 3/8" long	M16971	SB	05/05/13	10								
Qty	Part Number	Description	Batch																						
2	AN960-416	Washer	M5519																						
1	HX-81	1/4"-20 SHCS 3/8" long	M16971																						
17	QC5	Inspect work to Step 16	2	05.05.16	10																				
18	PK	Ensure that keys are attached to D3368-041 and D3393-041 <b>Pick:</b> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3368-041</td> <td>Pedal Lock Assembly</td> <td>B23161</td> </tr> <tr> <td>1</td> <td>D3393-041</td> <td>Battery Lock Assembly</td> <td></td> </tr> </tbody> </table> <b>Ensure that keys can be locked and unlocked for each D3368-041 and D3393-041 assembly.</b>	Qty	Part Number	Description	Batch	1	D3368-041	Pedal Lock Assembly	B23161	1	D3393-041	Battery Lock Assembly		CL	05/05/16	10								
Qty	Part Number	Description	Batch																						
1	D3368-041	Pedal Lock Assembly	B23161																						
1	D3393-041	Battery Lock Assembly																							
19	QC4	Inspect Kit 100% for Completeness on the W/O <u>N/A</u>																							
20	PK	Identify and pack for shipping as per PPP D412-738-011 <u>ID + stock</u>	CL	05/05/16	10																				
21	AC	Cost / part: <u>91.53</u>	Sur	05.06.01	10																				
22	DC	Close W/O <u>91.53</u> Inspect Level 21	CL	05.06.03	10																				

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05/05/2016

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

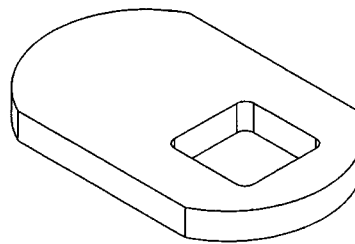
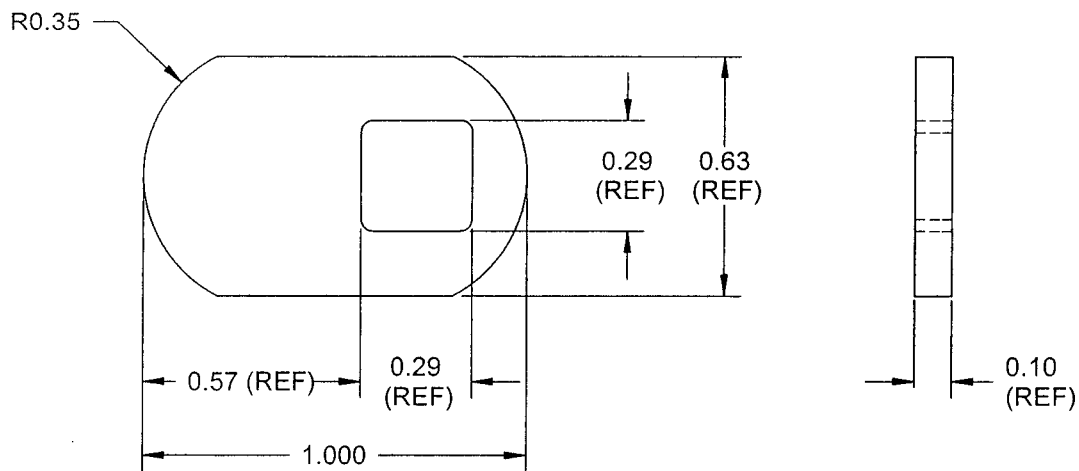
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3371	REV. B SHEET 4 OF 4
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 2:1

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05/04/28

## SPECIFICATION CONTROL DRAWING



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WORK ORDER

NO. 23161

D3371-5 CAM

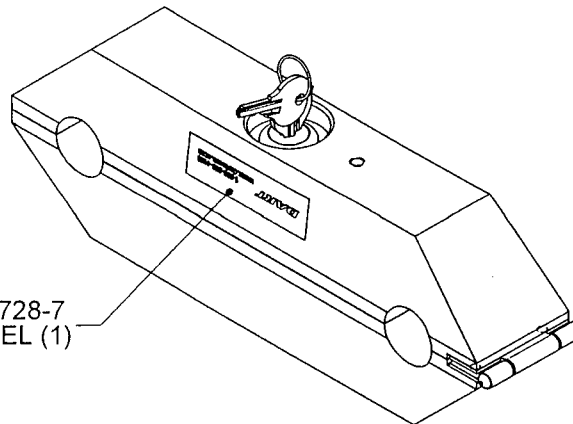
### NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



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DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

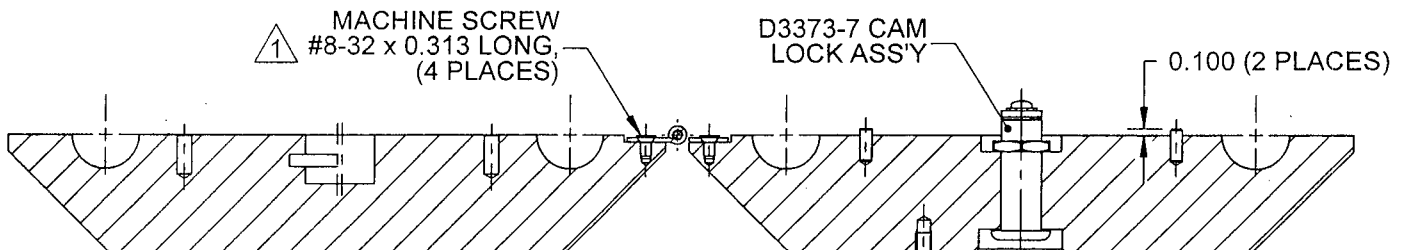
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WORK ORDER  
NO. 23161



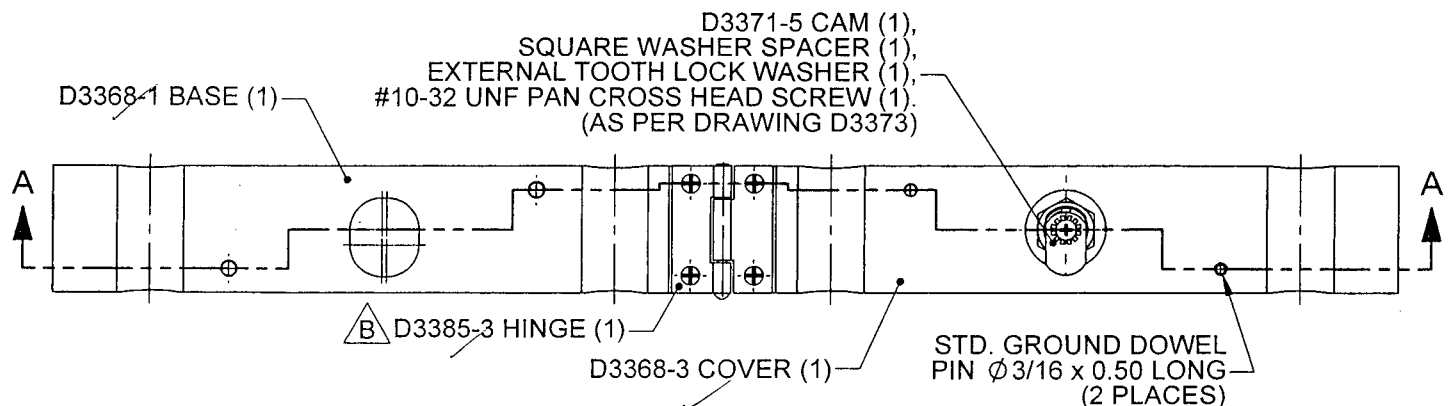
D2728-7  
LABEL (1)

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05/04/20

**PEDAL LOCK SHOWN LOCKED WITH KEY**



**SECTION A-A**



**D3368-051 PEDAL LOCK ASSEMBLY**

**NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAU P/N 385-044
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3368</b>	REV. B SHEET 2 OF 3
DATE <b>05.03.22</b>	TITLE <b>PEDAL LOCK</b>		SCALE 1:2.5

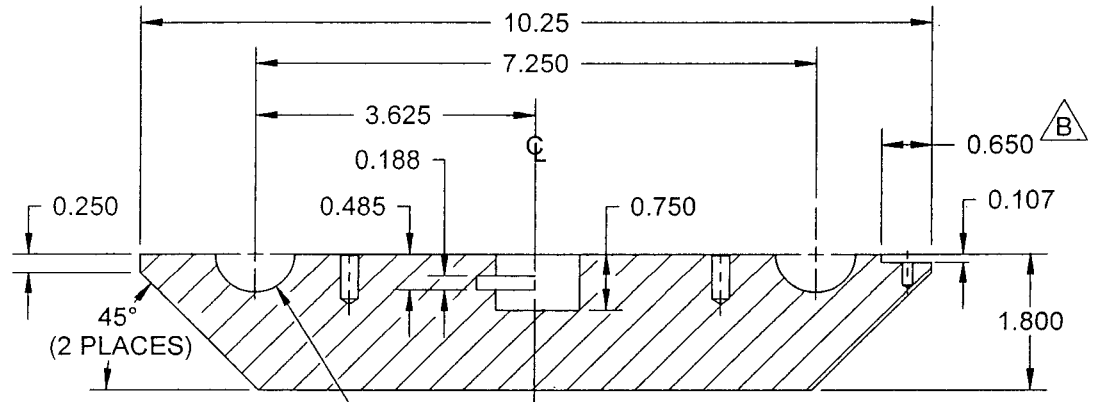
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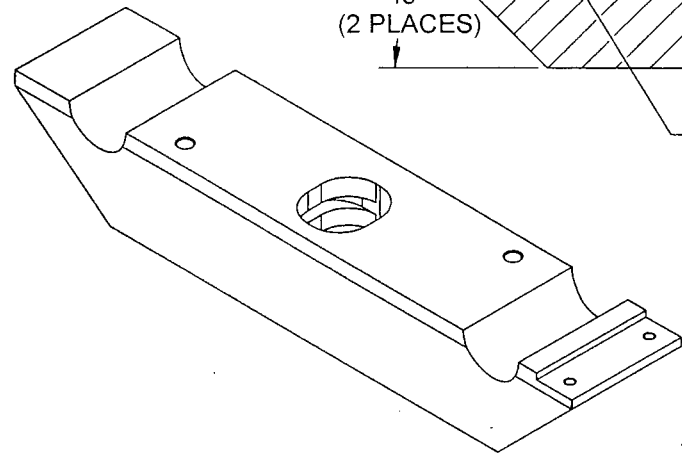
WORK ORDER

NO. 23161

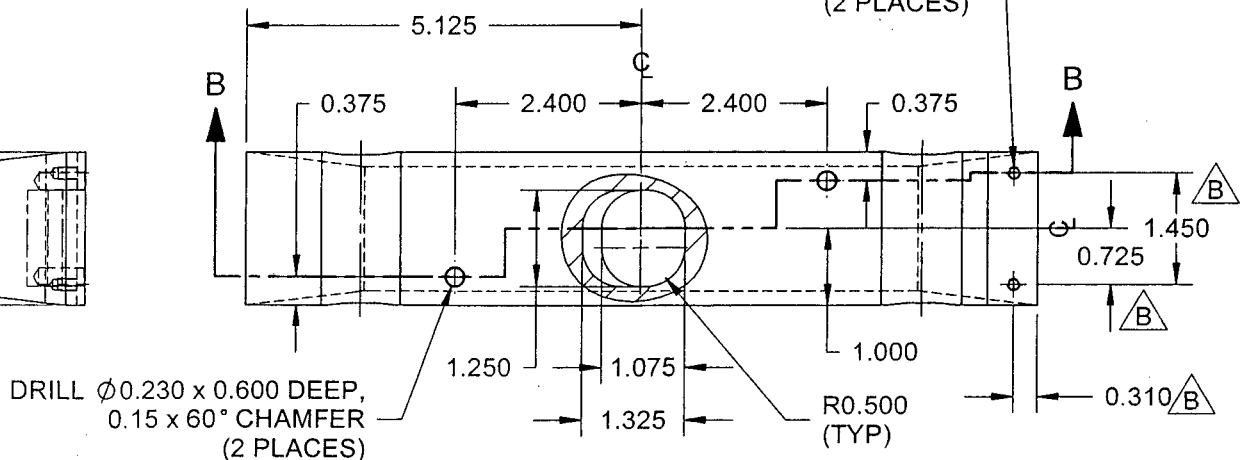
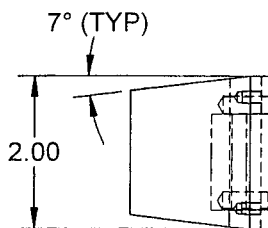


**SECTION B-B**

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*[Signature]*  
05/04/23



**B** DRILL Ø0.136 x 0.300 DEEP, 2  
TAP 8-32 UNC TO BOTTOM OF HOLE (2 PLACES)



**D3368-1 BASE**

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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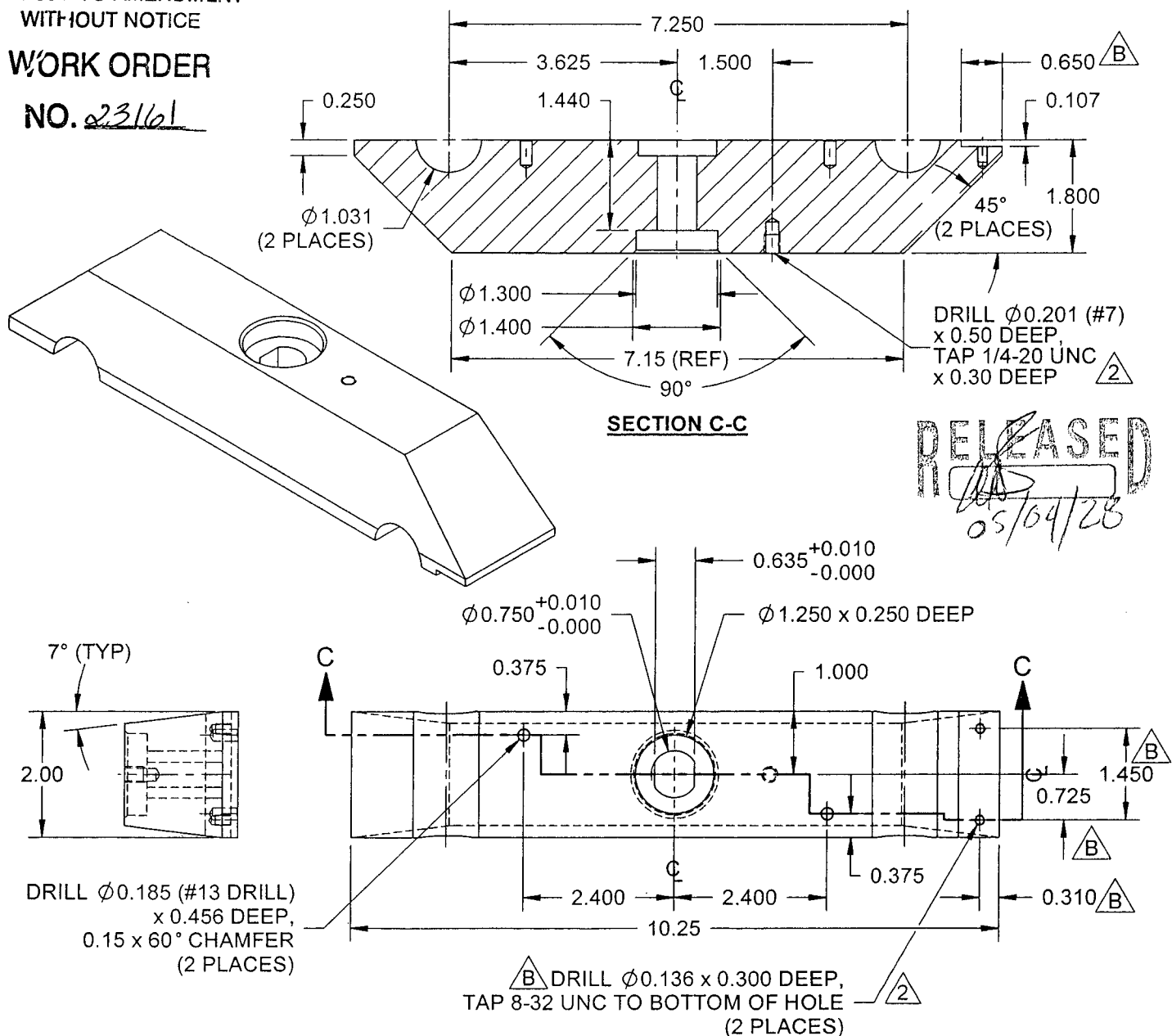
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. B SHEET 3 OF 3
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2.5

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WORK ORDER

NO. 23161



### D3368-3 COVER

#### NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)  
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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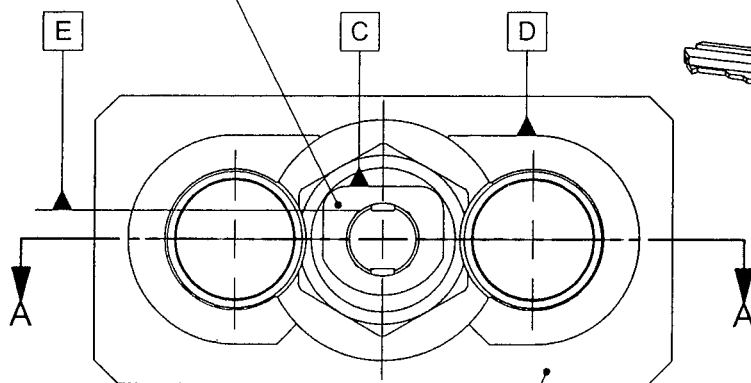


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3393</b>	REV. A SHEET 1 OF 3
DATE <b>05.02.08</b>		TITLE <b>BATTERY LOCK</b>	SCALE 1:1
A	05.02.08	NEW ISSUE	

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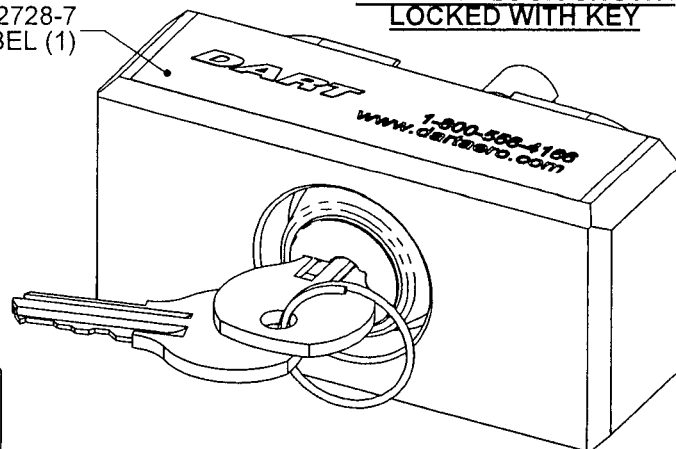
05/03/09

POSITION FACE **C** OF D3369-5  
PARALLEL TO FACES **D** AND **E**  
AS SHOWN



D2728-7  
LABEL (1)

**BATTERY LOCK SHOWN  
LOCKED WITH KEY**



D3373-1  
CAM LOCK  
ASSEMBLY (1)

D3393-1  
CASING (1)

Ø5/16" WC S/S  
WASHER (2)

D3369-5 SPACER (1)

PRESS FIT POLYETHYLENE CAP (2)  $\frac{2}{2}$   
AND APPLY KRAZY GLUE

D3393-3 CAM  
LOCK SHAFT (1)

0.09<sup>+0.03</sup>  
-0.01 (2 PLACES)

TACK WELD  
D3393-3 TO D3369-5

**SECTION A-A**

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**WORK ORDER**

**NO. 23161**

**D3393-041 BATTERY LOCK ASSEMBLY**

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMaster-CARR, P/N 9567K21

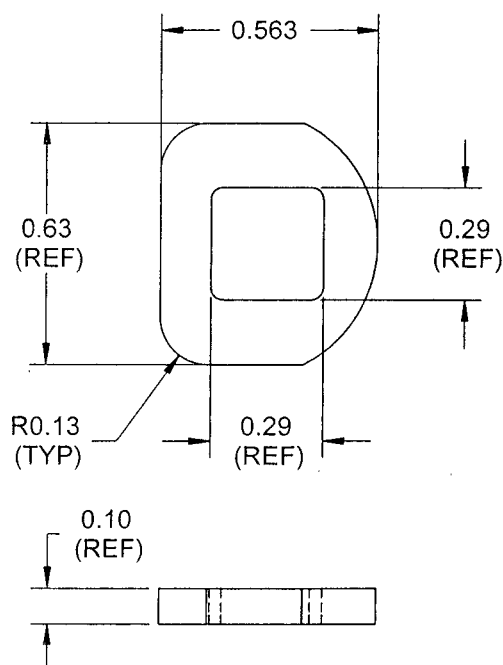
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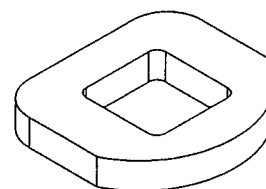
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3369	REV. A SHEET 4 OF 4
DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

## SPECIFICATION CONTROL DRAWING



RELEASED  
*[Signature]*

05/02/11



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 23161

-5  
D3369 SPACER



### NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

May 06, 2005  
09:55 am

Work Order No : 0023161  
Project Name : D412-738-011  
Project For : WK521  
Work Order Type : Main  
Main WO Number :  
House Part Number : \*D412-738-011  
Description : Dual Disabling Kit  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 05-04-05  
Est Finish Date : 05-26-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00